



Low carbon martensitic or low carbon dual phase (ferrite plus martensite) stainless steel containing 10.5 to 14% chromium content by weight. ← 11

Trim Edges of Plate or Coil to Remove Surplus Width, Edge Cracks and Insure all Oxide is removed. ← 13

Form Plate or Coil through Continuous Roll Forming Mill ← 16

Autogenous Electric Resistance Weld with Induction High Frequency Welder ← 19

Remove Internal and External Squeeze Weld Bead ← 22

Optional Post Welding Heat Treat of the Weld Seam and Adjacent HAZ of Full Body of the Pipe ← 25

Ultrasonic or Electro Magnetic Inspection of the Weld Line or of the Weld Line and the Full Body of the Finished Pipe ← 30

Finished Dual Phase or Martensitic Stainless Steel Pipe ← 32

Fig. 1

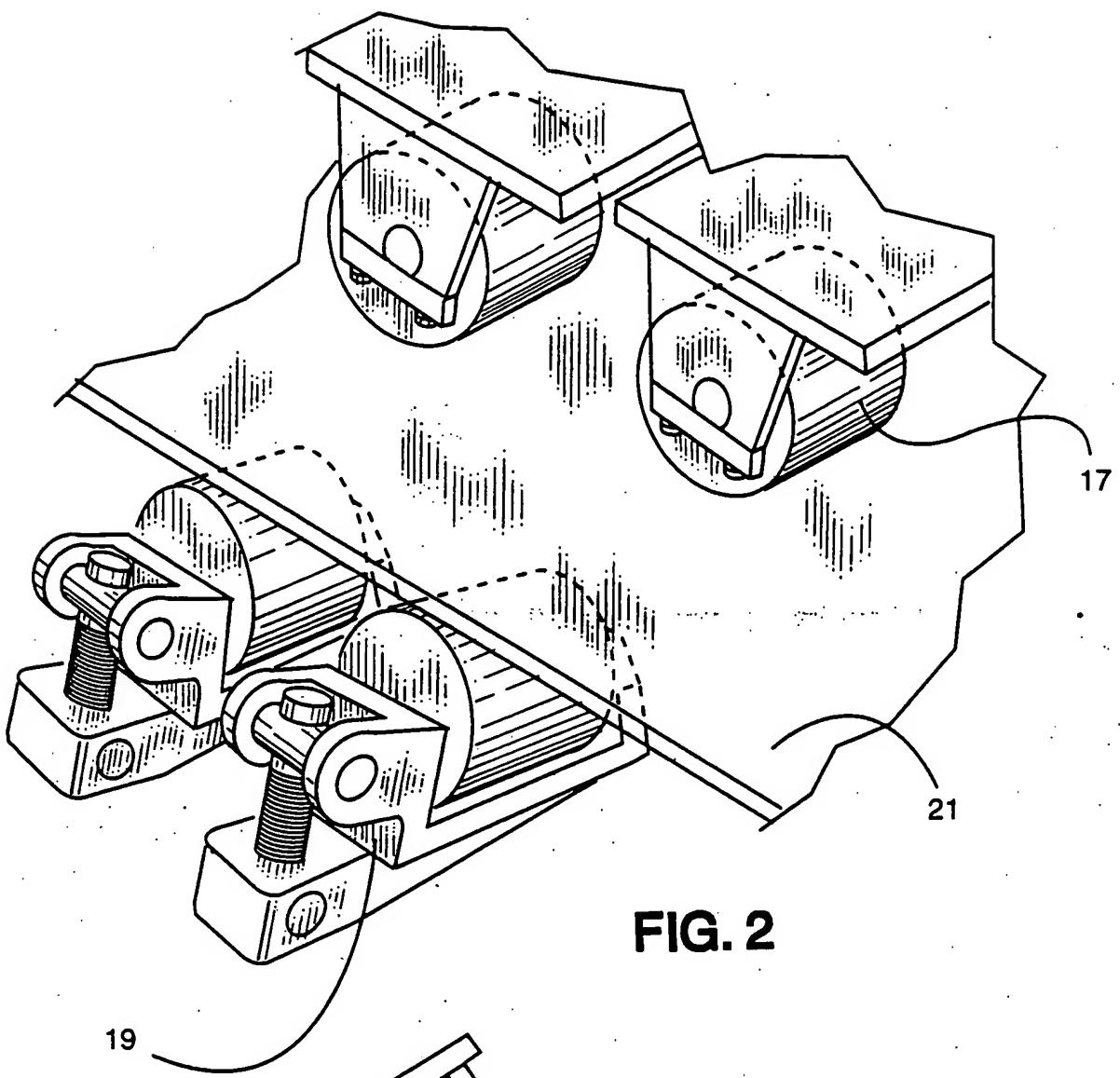


FIG. 2

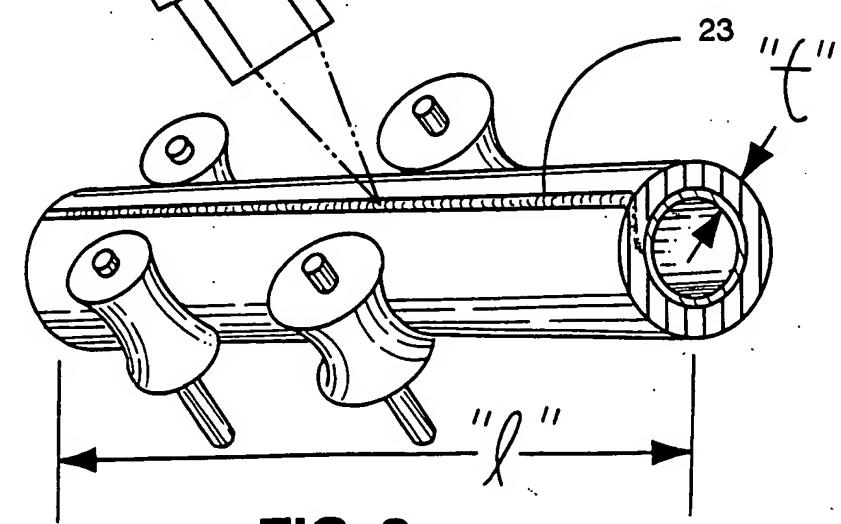
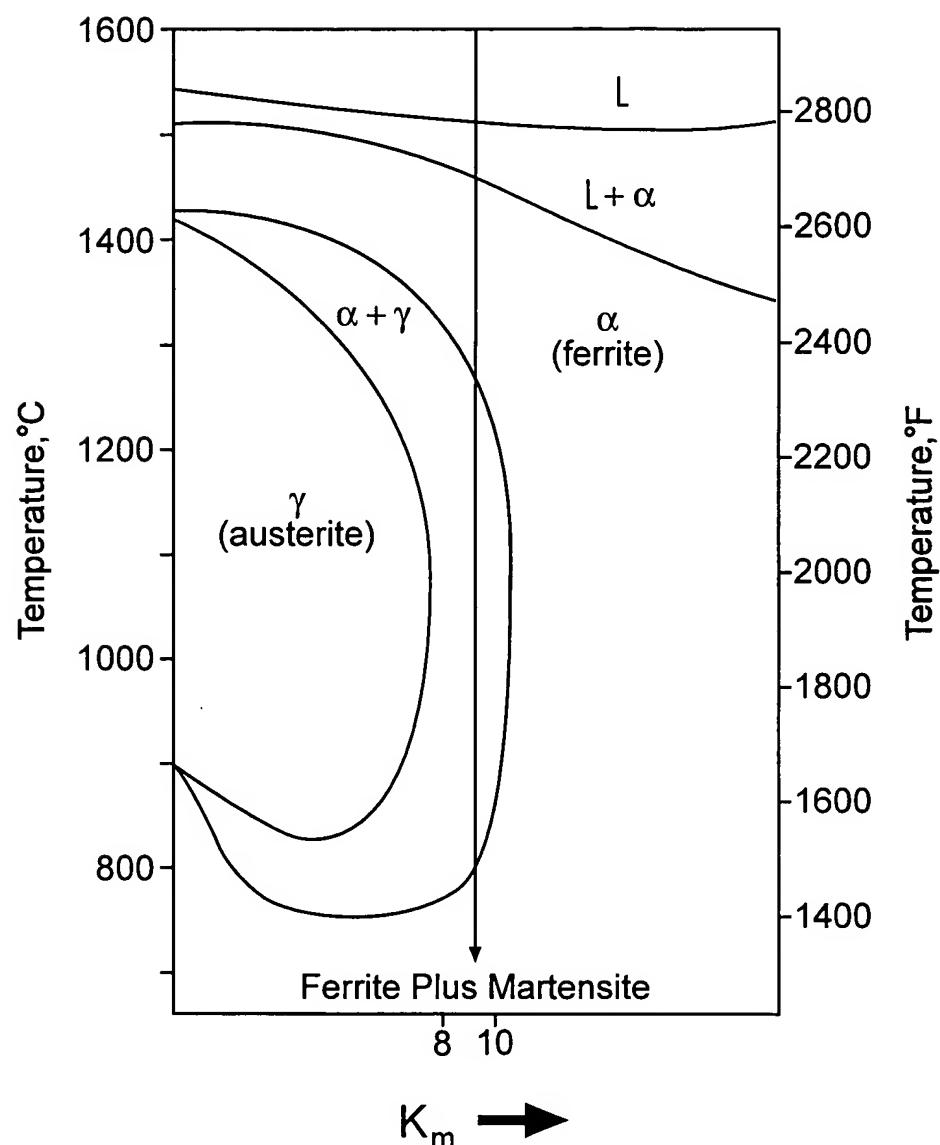


FIG. 3



Chemical Balance For Dual Phase Microstructure

$$K_m = Cr + 6 Si + 8 Ti + 4 Mo + 2 Al - 2 Mn \\ - 4 Ni - 40(C+N) - 20 P - 5 Cu$$

Fig. 4